

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000356**Date Inspected:** 11-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Chuck Franco was present at the time requested to randomly observe welding being performed on a Procedure Qualification Record (PQR). The welding is being attempted with the submerged arc welding (SAW) process in the 1G or flat groove position. The PQR weld joint is a single V groove with a 20 degree included groove angle, a 16 millimeter root opening with a 20 millimeter thick by 200 millimeter wide steel backing strip. The QA Inspector observed ZPMC CWI Huang Wei monitoring preheat, welding amperage and welding voltage. Mr. Wei was being assisted by Fu Jun of the ZPMC Technological Department, who was monitoring travel speed and recording all weld parameters. The QA Inspector also performed random verification of the above weld parameters and documented same. The attached photograph provides additional detail.



WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Conversations:

Mr. Wei informed the QA Inspector that no further PQR's would be performed until Wednesday or Thursday of next week.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
